

Date: Sunday, 12/4/2005 12:48:35 PM
 User: Linda Lecelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350 BASKET LID (SHORT)		
Job Number	: 25094B		Part Number	: D3266041		
Estimate Number	: 10210		Drawing Number	: D3266-041 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/4/2005 S.O. No. : N/A		Drawing Revision	: A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 1/30/2006 Qty: 1 Um: Each		
Previous Run	: 25093B		Type	: LARGE FAB ASSY		
Written By	: <u>SEE COMMENT Below</u>					
Checked & Approved By	: <u>SEE PROVE LSR & DATE</u>					
Comment	: Est Rev:B Re-Format 05-11-03 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D31663	Basket Hoop		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty 1 D3166-3 Basket Hoop Batch: <u>B 26382</u>		<u>AA 06/04/17</u>
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W		
		Comment: Qty.: 28.3500 f(s)/Unit Total : 28.3500 f(s) 3/4" x 3/4" square tubing as per Dwg D3266 Material: 304/316 SS tube .063" wall(M304TS0750W065) Batch: <u>M100282 - 112 1/2"</u> <u>(M100138 - 142 3/4")</u>		<u>AA 06/04/17</u>
3.0	D22321	Hinge		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2232-1 Hinge plate <u>B24823 - B23445</u>		<u>AA 06/04/17</u>
4.0	D23271	Spacer Bushing		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2327-1 Bushing <u>B24823</u>		<u>AA 06/04/17</u>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 D2506 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2506

Label Plate B24875

AA 06/04/17

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket B26204

AA 06/04/17

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 10.0000 sf(s)/Unit Total : 10.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

10sf M304EX0.75-16F

Expanded Metal M100722

AA 06/04/17

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236 From D3166-3

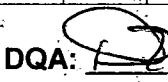
2-Cut 3/4" x 3/4" square tubing as per Dwg D3266

3-Drill holes in D3266-1 as per Dwg D3266 using Drill Jig DT8305

4-Deburr & Remove all markings from material

5-Weld as per Dwg D3266 using Welding Table and corner Jig Deburr as required

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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Seq. #: Machine Or Operation:

Description :

9.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-04-24

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m ~~06-04-25~~ 06/04/25 (1)

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Batch: M100632
and Spray Paint black Batch: M19640
as per Dwg D3266 and QSI 005 4.4

a.m 06-04-28 (1)

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



06-05-02

Comment: Inspect Powder Coat and Wing Walk

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

 06/05/03 (1)

Job Completion



 06/05/03

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